

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018188**Date Inspected:** 14-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BE to Segment 11CE – PP 100 to PP 101

OBG # BAY 14 (13BE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 13BE – PP 121 to PP 121.5

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OBG # BAY 14 (13CE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 13CE – PP 123 to PP 123.5

OBG # BAY 14 (13CE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 13CE – PP 124 to PP 124.5

OBG # OUTSIDE YARD (12AW)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the FL3-WT stiffeners to verify the horizontal and vertical offset using 1000mm straight edge and bridge cam gauge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 12AW – PP 110 to PP 112

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11DW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 011 in the (4G) overhead position on side and bottom panel piece mark no. SEG069A. The location was the complete joint penetration groove weld joining the bottom and side panel of segment 11DW at work point W3. The welder ID was 046709. The welding was performed against welding repair report B-WR16939 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11DW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 021 in the (4G) overhead position on side and bottom panel piece mark no. SEG071A. The location was the complete joint penetration groove weld joining the bottom and side panel of segment 11DW at work point W4. The welder ID

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was 046709. The welding was performed against welding repair report B-WR16940 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
